

Work Order ID 58222

April 29, 2010 11:38:59 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 29/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run

Start

Stop

Sequence ID/
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CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

① BE 10/05/06

8 10/05/06

④

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Run Start



QC: _____

Date: _____

SPC (Y/N): _____

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Stop

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QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R□□□ Aluminum Rod

m112880

BE 10/05/06

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

m112860

BE 10/05/06

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

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Stop

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Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8.10.13

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8.10.13

Quality Control

(16)

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

① BR 10-5-13.

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QC: _____

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Stop

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QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114207

0.00

=> del 10/05/14

1 0

Powder Coating

Memo

START TIME:

9:00 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

4:30 AM

0.00

190



QC

QC3- Inspect Part Finish

0.00

① del 10-5-17.

Quality Control

Memo

0.00

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112427 ☐ ☐ ☐
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112429 ☐ ☐ ☐
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 1146132

①

10-5-18

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start



Stop

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QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPPD 57287

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

(70)

10/05/19

10/05/2019

MF 10-5-19

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 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 8.0000 1



205 Skidtube bent detail

B58112

Location	Loc Qty	Loc Code
LG	8	
57028	1	
57188	1	
57347	2	
57902	2	
57938	2	

① 10-5-4

D2576-3 Manufactured No 140 Each 114.0000 1



Step (maching detail)

Location	Loc Qty	Loc Code
LG	114	
46661	66	
52215	48	

1 BE 10/05/06

D2579 Manufactured No 140 Each 273.0000 20



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	273	
57052	13	
57348	260	

20 BE 10/05/06

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 112.0000 1



Cap

Location	Loc Qty	Loc Code
FP6	2	
56613	2	
ST026	110	
50513	1	
50770 ✓	29	
51539	26	
53791	54	

AN3-5A Purchased No 200 Each 991.0000 2



Bolt

Location	Loc Qty	Loc Code
ST350	991	
105057 ✓	991	

AN960JD10L Purchased No 200 Each 4,379.000 2



Washer

Location	Loc Qty	Loc Code
ST348	4379	
110985 ✓	4379	

ALS7-1032-130 Purchased No 200 Each 30.0000 50



Insert

ALS4-1032-130.

114654

Location	Loc Qty	Loc Code
ST282	30	
113238	30	

50 BR 10-5-18

April 29, 2010 11:39:04 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 2,355.000 50



BOLT

Location	Loc Qty	Loc Code
ST350	2355	
114103	501	
114108	300	
114330	54	
114416	500	
114523 ✓	1000	

AN960C10L Purchased No 200 Each 0.0000 50



washer

D3566-13



Gasket

MAS1149C0332R

114341

50 BR 10-5-18

50 BR 10-5-18

Manufactured No 200 Each 41.0000 1

Location	Loc Qty	Loc Code
FP	41	
53461 ✓	41	

D3566-5 Manufactured No 200 Each 31.0000 1



Gasket

Location	Loc Qty	Loc Code
FP015	31	
56829	1	
57526	10	
57682 ✓	20	

1 BR 10-5-18

1 BR 10-5-18

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 58.0000 2



Gasket

Location	Loc Qty	Loc Code
FP015	58	
57257	1	
57715 ✓	36	
58182	21	

2 BL 10-5-18

D3564-11 Manufactured No 200 Each 4.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FP19 57957	4	
57259	4	

1 BL 10-5-18

D3564-13 Manufactured No 200 Each 22.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FP17	22	
56533	10	
57684 ✓	12	

1 BL 10-5-18

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Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-9 Manufactured No 200 Each 15.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FP	1	
55334	1	
FP019	14	
57260	3	
57685	11	

D3564-5 Manufactured No 200 Each 7.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP19	5	
57525	5	

D2594-3 Manufactured No 200 Each 99.0000 16



O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	99	
55546	99	

1 BK 10-5-18

1 BK 10-5-18

16 BK 10-5-18

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IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

D2594-1

Manufactured No

200

Each

526.0000

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP

526

42807

112

55002 ✓

208

57826

206

16. 6R 10-5-18.

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *58222*

BS10-4-29

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

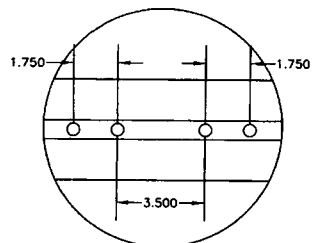
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

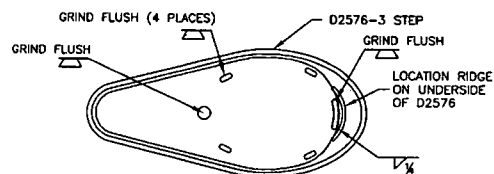
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

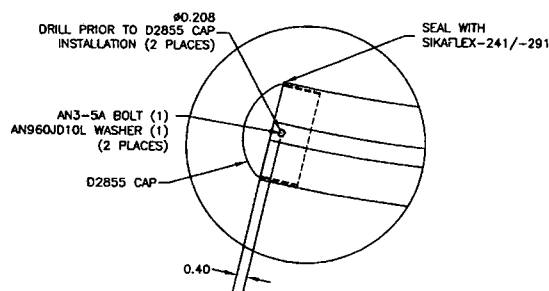


DETAIL B
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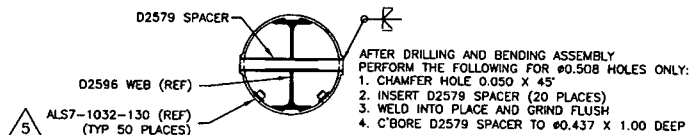


RELEASED
07.06.28

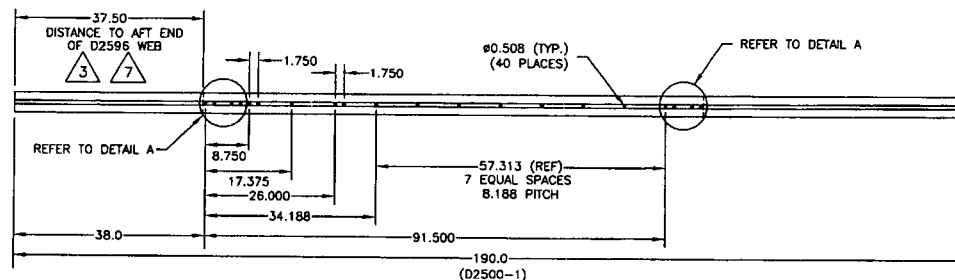
DETAIL C
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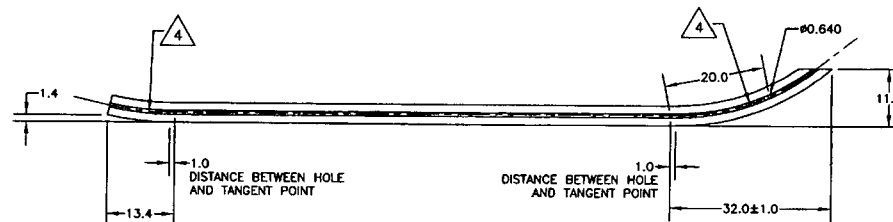
SECTION D-D
SCALE 5:24



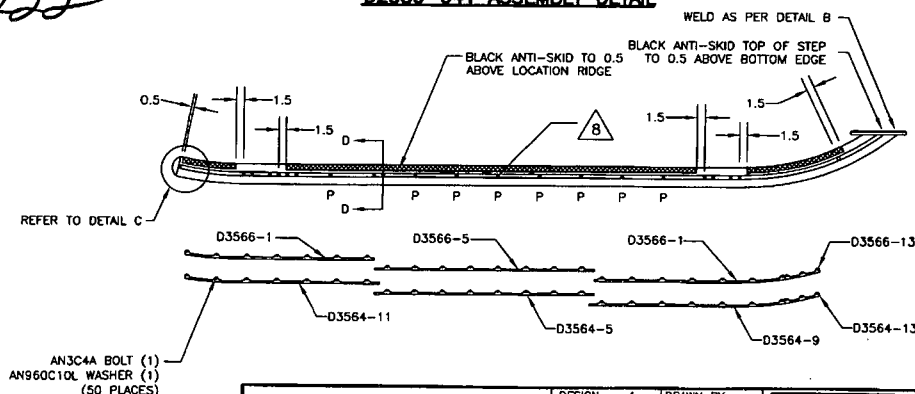
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

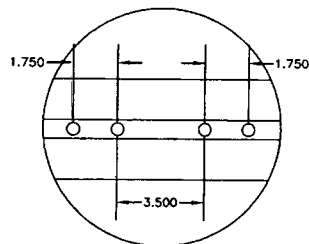
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

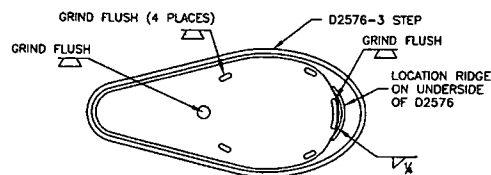
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

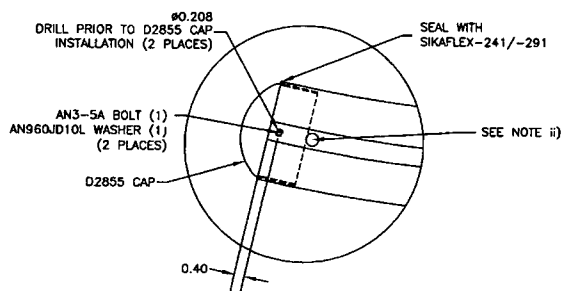


DETAIL F
SCALE 5:24

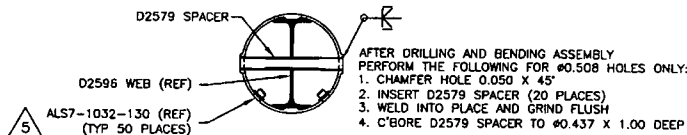


RELEASED
07 Dec 88

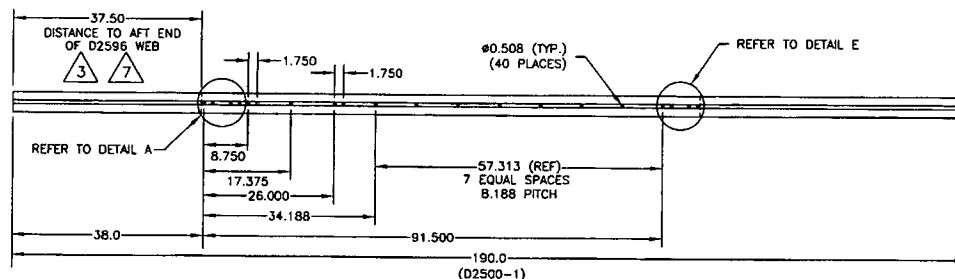
DETAIL G
SCALE 5:24



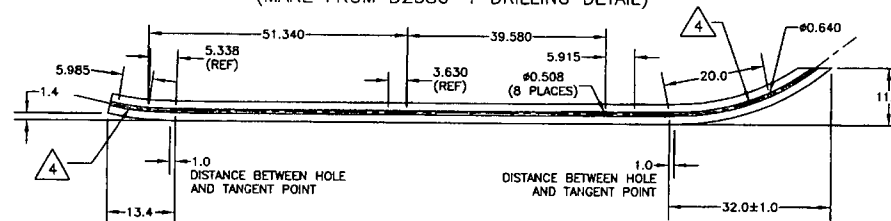
SECTION H-H
SCALE 5:24



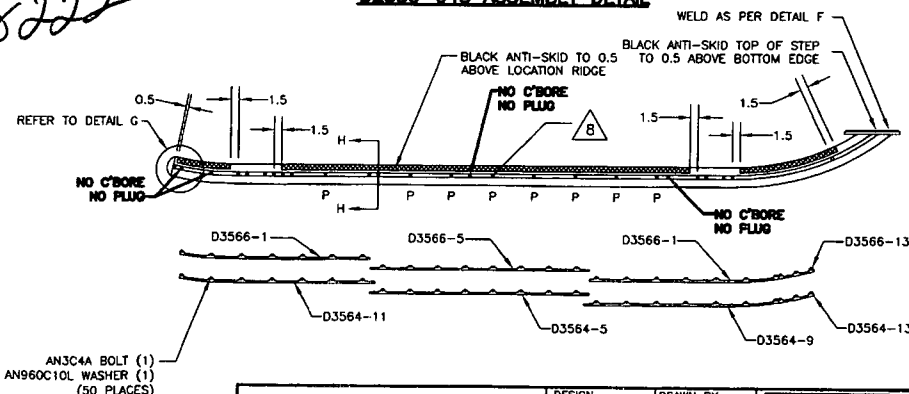
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	TITLE	D2580	SHEET 3 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY		SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 57683
Part number: D205-634.041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.04.27

Welder [Signature] Date of Test Coupon 10.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld